Work Orde		853		*105	5853*							Page	1
Item ID: Revision ID:	D3914-041			Accept	*N900	040	10	N* .	Setup S		*N:	S1*	
Item Name:	Long Basket Li	d Assembly (350)					•		S	Stop	*N:	S2*	
Start Date:	8/22/13	Start Qty: 1.00	*1*	•	Cust Item 1	ID:				•			
Required Date: Reference:	9/05/13	Req'd Qty: 1.00	*1*	.	Customer:			ŧ					
Approvals:	Process Plan	: MLJ	Date: 13-08	22 Tooling:	D	ate:	- ·	•		tart	*N	R1*	
	QC:		_ Date:	SPC (Y/N):	D	ate:	 -		S	Stop	*N	R2*	٠.
Sequence ID/ Work Center II		Operation Description		, Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accep Qty	t Reject Qty		leject lumber	Insp. Stamp	,
Draw Nbr	Revis	ion Nbr				· -							
D3914 D4020	C A	<u>)</u> :										Λ	
100 *100* Lerge Fab		Weld per dwg A/R S.S. Large Fab	rod Batch: 124,	0.00				/x	Ø		(pl	
Large Fab		Memo 1- assemble	ribs , weld as per dw	0.00 g D3914 using DT9607A								13.4	7.6
		2- weld hing		rackets as per dwg 1)3914								, ,	, -
			l mesh on basket as pe										
		***Cut out: D4020-5, M tacking mes	lake sure to place mes	e goes in center off basket lid h correctly on lid, check with I	as per dwg . label plate before			1	,		,		
110		QC9- Inspect visual per	OSIONA - Fueion Wald	s 0.00		٠.	,					- 4	
110		Memo	QSIVOT- I USION WOL	0.00			•	<u>B</u> .	<u>083</u>	o	· - -	(09 (09 (28)

Quality Control

										DQA:	Date:		
NCR: Y	es / No				WORK ORDER NON-C	100	NFOR	MANCE / UPDATE		QA Closed:	Date:		
Work Orde	or.				DISPOSITION			AGA	INST DE	PARTMENT/	PROCESS	<u>- </u>	
Part N	lo			· · · · · · · · · · · · · · · · · · ·	Rework Scrap Use-as-is Work Order Update		Thern	Skid-tube Cross Machining Small noforming Finis Large Fab Compo	Fab hing		Water Jet 1. Eng. Coor. e/Packaging Supplier	Engineering Quality Other	
Root			ľ	Descri	ption of work order update	П	Initial	Action		Sign &			
Cause	Date	Step	Qty	l .	or Non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector	
Doc/Data	, , , , , , , , , , , , , , , , , , ,												
Equip/Tooling Operator				, ,	•					· .			
Material		•											
Setup	-					'				.]			
Other		1							•				
Process					•								
Supplier		Ì	ļ		•			*	٠		•	:	
Training		i											
Unapproved			1										
			•		F	AUL	T CATE	GORY					
Landir	ng Gear				General					•			
	Bending				Bend.		Grain			Ovalized '		Pressure/Forced	
	Centre N	ot Conce	ntric to	o/s	BOM/Route] Hardwa	re		Over/Under 1	tolerance	Temperature/Cure	
	Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorrec	t	Weld	
	Crushed/	Crimped		·	Burrs		Instruct	ions Incomplete/Unclear		Part Lost/Mis	ssing	Wrong Stock Pulled	
	Cuffs				Contamination		Mainte	nance	┕	Part Moved			
	Heat Trea	at .			Countersink		Mislabe	led		Positioned W		•	
	Inspectio	n Strip in	Tube		Cut Too Short		Misread			Power Loss/S	Surge	Other	
57	Ripples in	n Bend		· L	Drill Holes		Offset						
€0	Torque V	Vaves in I	Extrusio	n	Drawing	Out of Calibration							

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Orde		5853			*105	5853*		-					Page 2
Item ID: Revision ID:	D3914-041				Accept	*N900	040	100)*	Setup	Start	*N:	S1*
Item Name:	Long Backet I	Lid Assembly (350)							•		Stop	*N1	CO*
		•		*4*	:						-	*N:	5 7"
Start Date: Required Date:	8/22/13	Start Qty: 1.00 Req'd Qty: 1.00		*1*		Cust Item I	D:						
Reference:	7/05/15	Key a Qiy. 1.00		*1*		Customer:							
Approvals:	Process Pla	in:	Date:		Tooling: _	D:	ate:			Run	Start	*NI	R1*
	QC:		Date:	 	SPC (Y/N):	D	ate:	·		•	Stop	*N!	R2*
Sequence ID/ Work Center I	D	Operation Description	,		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
120		QC5-Inspect part comp	leteness to step	on W/O	0.00	•						•	DAG,
120		Money	, :		0.00					13- <u>0</u> 5	<u>3-3</u> 0)	109
Quality Control		Memo · .			0.50								
130		Black Sandtex(Ref:4.3.5	5.7) per QSI00	5 4.3	0.00					, ;	• .	,	
130				/ \					IXU	7 M	11/1	113	104/0
Powdercoat		Memo	. /	, ५३	0.00				79				
Powder Coating	128	*** mask si Start Time: Oven Temp	ides of hinge p erature:	ior to powder	Coat								
MILL	53°	Finish Time	+1+	20	_								•
140		Wing Walk as per dwg (QS1005 4.4 Ba	M1260	83 .00					,		,	
1 ⊿ ∩			,					•	1	Ø	D	13-	93.
HandFinish		. Мето			0.00			٠.					
Hand Finishing		1- Mask dat	ta plate and ap	ply wing walk	on outside surface of m	nesh as per dwg				•			
		***Mask la	acard and labe abel plate to sin ply label ***	l as per dwg ze of label, us	se scotchbrite red pad to	lightly sand area							

										DQA:	Date:	
NCR: Y	es / No				WORK ORDER NON-C	CON	FORN	/ANCE / UPC	DATE			
								<u> </u>		QA Closed:	Date:	<u> </u>
Work Orde	· · · · · · · · · · · · · · · · · · ·				DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
WOIK OIGC					Rework	1		Skid-tube	Crosstube		Water Jet	Engineering
Part N	lo	•			Scrap	1 1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is	1	Therm	noforming	Finishing	Rec/Stor	e/Packaging	Other
NCR N	lo.				Work Order Update	1		Large Fab	Composite		Supplier	
_	<u> </u>								•			
Root					ption of work order update	1	itial	Acti		Sign &		,
Cause	Date	Step	Qty	(or Non-conformance	Chie	ef Eng	Descri	iption	Date	Verification	QC Inspector
Doc/Data			[
Equip/Tooling						1		1				
Operator	_	ŀ						1				
Material	_						1	1	•			
Setup								1				
Other												
Process		1				1				•		
Supplier	_	-				1						
Training												
Unapproved		.1	<u> </u>			1	CATE	CORY	.			
				.	General	AULI	CATE	JURY		-		
Landii	ng Gear				Bend		Grain			Ovalized	Г	Pressure/Forced
	Bending	lot Conce	ntric to	رر <u>ا</u>	BOM/Route	\vdash	Hardwa	ro	<u> </u>	Over/Under	tolerance	Temperature/Cure
		ot conce	ntric to	U/3 -	Broken/Damaged	\vdash		ion Incomplete	-	Part Incorre	<u> </u>	Weld
	Cracks	/Crimped			Burrs	\vdash	-	ions Incomplete/U	Inclear	Part Lost/Mi		Wrong Stock Pulled
	Cuffs	Crimpeu		-	Contamination	_		nance		Part Moved	33111B	Try on B stock (amea
	Heat Tre	est			Countersink	\vdash	Mislabe		—	Positioned V	Vrong	
	_	ar on Strip ir	Tube	\vdash	Cut Too Short	\vdash	Misread		 	Power Loss/		Other
	Ripples i		, rube		Drill Holes		Offset	,	<u> </u>	1. 22. 2227		1 - 1 - 1
		Naves in I	Extrusio	n	Drawing Out of Calibration			Calibration				

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Ord August-22-13		5853		*10	5853*						Page 3
Item ID: Revision ID: Item Name:	D3914-041 Long Basket I	Lid Assembly (350)		Accept	*N900	<u>1040</u>	100)*	Setup Sta	171	S1* S2*
Start Date: Required Date Reference:	8/22/13	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item Customer:						
Approvals:		an:	Date:			ate:	· 			OD.	R1* R2*
Sequence ID/ Work Center 1 150 *150* QC Quality Control	ID	Operation Description QC3- Inspect Part Finish Memo		Set Up/ Run Hours 0.00 DAS 27 0.00 9-89 /3 9		Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* Packaging Packaging		Identify as per dwg & Stoc	k Location DHD7	0.00	105852			_/	<i>ф</i>	BL 13-	9-3.
170 *170* QC Quality Control		QC21- Final Inspection - V	Vork Order Release	0.00					13	19/11	\$
								d	16-09-1	9	

											DQA:	Date	·
NCR:	⁄es	/ No				WORK ORDER NON-C	100	NFORM	MANCE / UPDATE		QA Closed:	Date	:
			•			DISPOSITION			AGAIN	ST DE	PARTMENT	/PROCESS	
Work Orde Part I	- . No.					Rework Scrap Use-as-is Work Order Update	t Therm	Skid-tube Crosstu Machining Small F noforming Finishi Large Fab Compos	ab ng	1	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other	
Root					Descri	ption of work order update	1	Initial	Action		Sign &		
Cause	Ì	Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Doc/Data	П				.								
Equip/Tooling	П]				l]		
Operator	Н						1						
Material	H												1
Setup	\vdash								•				
Other	H						ļ						
Process	Н		1										
Supplier	Н												
Training										•]		
Unapproved	П		<u> </u>										<u>l</u> .
						F	AUL	T CATE	GORY	_		·	
Landi	ng G	iear			_	General		_			•	_	_
	П	Bending				Bend		Grain			Ovalized	_	Pressure/Forced
Centre Not Concentric to O/S BOM/Route					o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
				Broken/Damaged		Inspecti	ion Incomplete		Part Incorred	ct [Weld		
	一	Crushed/	Crimped			Burrs		Instruct	ions Incomplete/Unclear		Part Lost/Mi	ssing	Wrong Stock Pulled
	\vdash	Cuffs	•			Contamination	\Box	Mainte	enance		Part Moved	_	_
	Heat Treat					Countersink Mislabeled Positioned Wrong					Vrong		

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Other

Power Loss/Surge

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

Work Order ID: 10: Parent Item: D3	914-041			10585									
	Long Basket Lid As	ssembly (350)	^ I	1)3914	1-N41*				tart Date: 8/22 Start Qty: 1.00		-	d Date: 9/0 ed Qty: 1.0	
Comments:	IPP Rev:A new is as per dwg revB DI PER DWG REV.pc REV.C DD VER	D 10.08.18 verifie 1 DD VERF:JL	ed by:E	EC IF	IPP : PP Rev:C 13.03 13.06.21 DWC								
Component Item ID/ Item Name	Replacement Item 1D	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
03914-1		Manufactured	No			100	Each	8,0000	2	2 0			
*D3914-1	*								**	(00	13.8	36.1	2
ib				Location		Land	()er	Los Cuda	 <u>ئ</u> ى	A.	-dr-ll		(1)
				WA004	<u>!</u>	<u>Loc (</u>	2	Loc Code		多/03	3365		(A)
V				***************************************	83645		2		_				\sim
				WA005			6		_		-		
					103365		2		_		_		
					81449		1		_		-		
		•			82131 87079		l !		-		- .		
					97660		1		_		-		
3914-7		Manufactured	No			100	Each	7.0000	2	2			
*D3914-7	*								**		(pC	13'8	<u>a8</u>
/				Location	1	Loc (Oty	Loc Code	•	BIO	0 888	? <u> </u>	-6
/				WA004			2		_	-		,	700
					100888		2		_		-		
				WA005			5		_		-		
					82928 88649		3		_		-		

Page 1

Picklist Print

											DQA:	Date	:
NCR: Y	/es	/ No				WORK ORDER NON-	COI	NFORI\	AANCE / UP	DATE			
											QA Closed:	Date	:
Work Orde	~ 					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
WORK OF GR	-					Rework	٦		Skid-tube	Crosstube	1	Water Jet	Engineering
Part N	VΩ.					Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	-	· -		·		Use-as-is	1		noforming	Finishing	⊣	re/Packaging	Other
NCR 1	No.			_	·	Work Order Update			Large Fab	Composite]	Supplier	
Root			<u> </u>		Descri	ption of work order update	Т	Initial	Act	tion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	nief Eng	Desci	ription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling	Ш						İ						
Operator	Ш												
Material											1		
Setup													
Other				ļ									
Process							-1					İ	
Supplier													
Training													
Unapproved				l								<u> </u>	<u> </u>
		-					FAUI	T CATE	GORY				<u> </u>
Landi	ng G	ear				General		_			-	_	_
		Bending				Bend	L	Grain			Ovalized	_	Pressure/Forced
		Centre N	ot Conce	ntric to	o/s	BOM/Route		Hardwa	re	_	Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct	Weld
Grushod/Crimpod Bury					, [Burrs		Instruct	ions Incomplete/I	Unclear	Part Lost/M	issing	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	nance		Part Moved		
	Г	Heat Trea	at			Countersink		Mislabe	led		Positioned \	Wrong	_
		Inspectio	n Strip in	Tube		Cut Too Short		Misread	1		Power Loss,	/Surge	Other
1		Ripples in	n Bend			Drill Holes	\Box	Offset			_		

Out of Calibration
Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

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Picklist Print August-22-13 9:47:18 AM								Page 2
Work Order ID: 105853	, , , , , , , , , , , , , , , , , , , ,	*105853*				,		
Parent Item: D3914-041		*D3914-041*						
Parent Item Name: Long Basket L	id Assembly (350)	().19 14-(14 (Star	rt Date: 8/	/22/13	Required Date: 9/05/13
					Sta	irt Qty: 1.	00	Required Qty: 1.00
D4018-5	Manufactured	No	100	Each	57.0000	9	9	lack
D4018-5					•	**		P(13.8.28
		Location	Loc	Oty	Loc Code		35	97693 (9)
		WA004		54				
V		97693		18				_
		97933		36				<u> </u>
		WA005		3				
		100347		3				- 0
D4035-043	Manufactured	No	100	Each	13.0000	2	2	
D4035-043 Lid Rib Assembly, Aft-(350 Basket)						**	,	p(13.8.28)
	•	Location	Loc	: Oty	Loc Code			B103960 -> (2
		WA004		6				_
V		103960		2				<u></u>
		97686		1				
•		97687		3				_
		WA005		7				
		81202		1				

81452 82988 98841

DQA:	Date:	

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

										QA Closed:	Date	:
Work Orde					DISPOSITION				AGAINST DE	PARTMENT,	/PROCESS	
Part N					Rework Scrap Use-as-is		F	Skid-tube Machining	Crosstube Small Fab Finishing		Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR N	lo				Work Order Update]		Large Fab	Composite	Necyston	Supplier	
Root				Descri	ption of work order update	ln	itial	Ac	tion	Sign &		_
Cause	Date	Step	Qty		or Non-conformance	Chie	ef Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data								-				
Equip/Tooling		1										
Operator [,		
Material [1										
Setup		1				ì				Ì		
Other [ł						
Process		1]		
Supplier												,
Training {						ŀ						
Unapproved												
					<u> </u>	AULT	CATE	GORY				
Landir	ng Gear				General				_	_		_
	Bending				Bend	Ш	Grain		_	Ovalized		Pressure/Forced
	Centre N	ot Conce	ntric to (o/s	BOM/Route	∐¹	Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	l l	nspecti	on Incomplete		Part Incorred	t	Weld
	Crushed/	Crimped			Burrs		nstruct	ions Incomplete/	'Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
. [Cuffs				Contamination		Mainte	nance		Part Moved		
	Heat Trea	at			Countersink	n	Mislabe	led		Positioned V	Vrong	_
	Inspectio	n Strip in	Tube		Cut Too Short		Misread	i		Power Loss/	Surge	Other
	Ripples in	n Bend			Drill Holes		Offset					
	Torque V	Vaves in I	Extrusio	n [Drawing		Out of (Calibration				
	Turning S	Sequence	ı		Finish		Out of S	Sequence				
	Wave/Tv	vist in Tul	oe .		Folio	Outside Dimensions						

Picklist Print August-22-13 9:47:18 AM									Page 3
Work Order 1D: 105853 Parent Item: D3914-041	t Lid Assembly (350)		05853*)3914-041*				art Date: 8		Required Date: 9/05/13 Required Qty: 1.00
D2581	Manufactured	No		100	Each	87.0000	2	2	A.
D2581 Mounting Bracket		Location WA004 103076 103952 70766 81253 82506 83230 85452 87706		<u>L</u>	87 24 49 2 1 2 3 2 2 2	Loc Code	**		(p(13.8.28 B103752→6
D2728-3 *D2728-3* Dart Logo label large	Manufactured	No		140	Each	0.0000	0 **	0	
D4016-3 *D4016-3* Hings Half, Lid	Manufactured	No		100	Each	68.0000	**B	1030	29-73 (pl 13.8.2)
			Location	L	oc Qtv	Loc Code			
			WA		40				
			103029		40				
			WA004		28				
			101043		12				

102214 104365

											DQA:	Date	e:
NCR:	Yes	/ No				WORK ORDER NON-C	O	NFORM	MANCE / UP	DATE	QA Closed:	Date	<u> </u>
						DISPOSITION				AGAINST DE			
Work Ord	er: _					DISF 03(110)	.			_	· · · · · · · · · · · · · · · · · · ·	_	
Part I NCR I	-					Rework Scrap Use-as-is Work Order Update			Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite			Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
	-							L					
Root			,		Descri	ption of work order update	l	Initial		tion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	nief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved					·		011	LT CATE	GORY				
						General F.	AUI	LICATE	GURY				
Landi		Bending			-	Bend		Grain			Ovalized	Г	Pressure/Forced
		Centre No	ot Concei	ntric to	o/s	BOM/Route Broken/Damaged		Hardwa	re on incomplete	F	Over/Under Part Incorre	 -	Temperature/Cure Weld
		Crushed/	Crimped			Burrs		Instruct	ions Incomplete/	Unclear	Part Lost/M	issing	Wrong Stock Pulled
	-	Cuffs	-			Contamination		Mainte	enance		Part Moved	_	
		Heat Trea	ıt			Countersink		Mislabe	eled		Positioned \	Vrong _	
		Inspection	n Strip in	Tube		Cut Too Short		Misread	t .		Power Loss/	′Surge	Other
		Ripples in	Bend			Drill Holes		Offset					
		Torque W	/aves in E	Extrusio	n	Drawing		Out of 0	Calibration				

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Finish Folio

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Picklist Print August-22-13 9:47:19 AM				Transcription			Page 4
Work Order ID: 105853		*105853*	•			- 18-7	
Parent Item: D3914-041		*D3914-041	*				
Parent Item Name: Long Basket	Lid Assembly (350)					t Date: 8/22/13 rt Qty: 1.00	Required Date: 9/05/13 Required Qty: 1.00
D4020-5	Manufactured	No	100	Each	2.0000	1 1	α
D4020-5 Mesh (350 Basket Long, Lid)					*	·*	B98400 - 1
		Location	Loc	Oty	Loc Code		¥ 12 100 ===(1)
		WA007		2		-	
		98400		2			
D4021-3	Manufactured	No	100	Each	52.0000	1 1	0.
D4021-3					*	·*	P(13.8-28
Data Plate		<u>Location</u>	Loc	Oty	Loc Code		B10/346-08
		WA004		52			_
		101346		42			
		80897		9		 ,	<u> </u>
		82507		į			

										DQA:	Dai	.е.	
NCR: Y	es / No				WORK ORDER NON-	CON	IFORN	/ANCE / UPD/	ATE	QA Closed:	 : Dat	:e:	
			<u> </u>		DISPOSITION	Ī	AGAINST DEPARTMENT/PROCESS						
Work Orde	er:				Dawark []			حادية فيادة	Crosstube	1	Water Jet	\neg	Engineering
Part N	lo				Rework Scrap	1	ī	Machining	Small Fab	Prod. Eng. Coor.			Quality
NCR No.					Use-as-is Thermoforming Finishin Work Order Update Large Fab Composit			Finishing Composite					
Root				Descri	ption of work order update	Îr	nitial	Actio	n	Sign &			-
Cause	Date	Step_	Qty		or Non-conformance	Chi	ef Eng	Descrip	tion	Date	Verification	<u> </u>	QC Inspector
Doc/Data												1	
Equip/Tooling												l	
Operator							Î	i				1	
Material								i				-	
Setup	- "	1						i				- 1	
Other		ļ						i				-	
Process			!			Ì		I					
Supplier												- 1	
Training								I			i	-	
Unapproved	,					<u></u>							
					F	AUL'	CATE	SORY					
Landii	ng Gear				General					1	ſ	_	
	Bending				Bend	\vdash	Grain		<u> </u>	Ovalized	,	—	Pressure/Forced
	Centre f	Not Conce	ntric to	D/S	BOM/Route	\vdash	Hardwa		<u> </u>	Over/Under		_	Temperature/Cure
	Cracks				Broken/Damaged	\vdash	-	on Incomplete		Part Incorre	ŀ	_	Weld
	Crushed	/Crimped		ļ	Burrs	\blacksquare		ions Incomplete/Un	clear	Part Lost/M			Wrong Stock Pulled
	Cuffs				Contamination	\vdash	Mainte		<u></u>	Part Moved			
	Heat Tre	eat			Countersink	Ш	Mislabe	led	<u></u>	Positioned \	-	,	
	Inspecti	on Strip in	Tube		Cut Too Short	1 1	Misread	I	Į	Power Loss/Surge			Other

Offset

Out of Calibration
Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

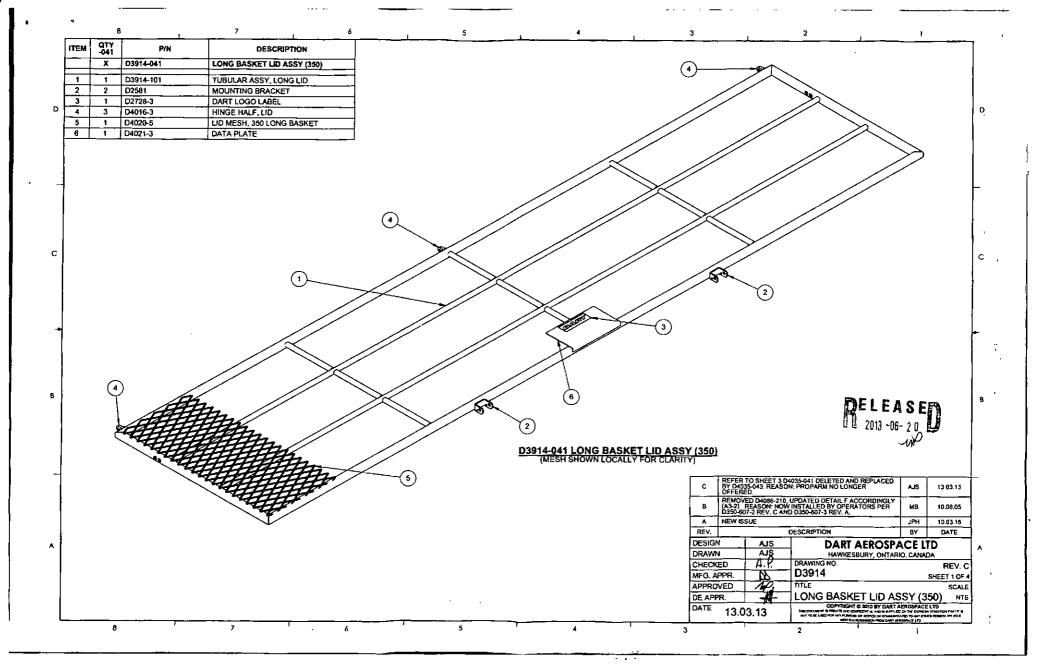
Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish Folio



TO NOTO

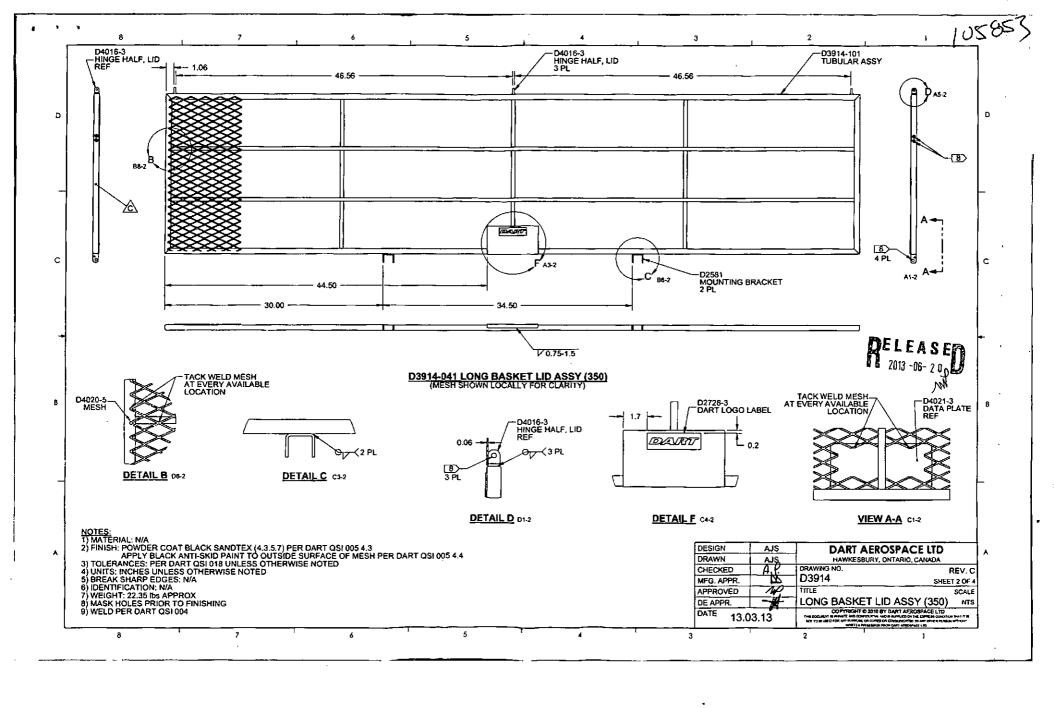
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PARAMENT

105853 MLJ 13-08-22

		DQA: Date:	
NCR:	Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE	

											QA Closed:	Date	e:		
Work Ord	er.		· 			DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part No						Rework Scrap Use-as-is Work Order Update			Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	Pro Rec/Sto	Engineering Quality Other			
Root		Description of work order update							A	ction	Sign &				
Cause	1	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	cription	Date	Verification	QC Inspector		
Doc/Data					-										
Equip/Tooling			!										·		
Operator			1												
Material	Ш														
Setup	Ц		ļ									į			
Other	Ш						ļ								
Process	Ш														
Supplier	Ш						1								
Training	Ц														
Unapproved			<u> </u>								<u> </u>	<u> </u>			
	_						AUL	T CATE	GORY			_ _			
Landi	ing (1			r	General		.			Ovalized	F	Pressure/Forced		
	-	Bending			- /s	Bend Bend	_	Grain		-	Over/Under	t-1	Temperature/Cure		
	\vdash	Centre No	ot Concei	ntric to	^{U/3} -	BOM/Route Broken/Damaged	\vdash	Hardwa	ire ion Incomplete	<u> </u>	Part Incorre	-	Weld		
	\vdash	Cracks Crushed/	Crimpad		}	Burrs	-	•	ions Incomplete	/Unclear	Part Lost/Mi	-	Wrong Stock Pulled		
	-	Cuffs	Cranpeu		-	Contamination		Mainte	•	- Circledi	Part Moved	1331116 L			
	\vdash	Heat Trea	at			Countersink	+	Mislabe		-	Positioned V	Vrong			
	\vdash	Inspectio		Tube	-	Cut Too Short	\vdash	Misrea			Power Loss/	_	Other		
	\vdash	Ripples in			-	Drill Holes		Offset		<u>L</u>		. U.			
		Torque W		xtrusio	n -	Drawing			Calibration						
		4 ·				Finish		_	Sequence						
		Turning Sequence Finish Wave/Twist in Tube Folio						Outside Dimensions							



											DQA:	Da	ate:	
NCR: Y	'es / No				WORK ORDER NON-C	O	NFORM	MANCE / UPI	DATE	OA (Closed:		ate:	
					DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Work Orde	er:				Rework	Skid-tube Crosstube				7	Water Jet			Engineering
Part N	No				Scrap Use-as-is	Machining Small Fab			}	Prod. Eng. Coor. Rec/Store/Packaging				Quality
NCR N	lo								Composite					
Root				Descri	ption of work order update	1	nitial	Act	ion	Si	gn &			
Cause	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Descr	ription		ate	Verification	n n	QC Inspector
Doc/Data						ĺ		LE						
Equip/Tooling						İ	į							
Operator														
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					F.	AUL	T CATE	GORY						
Landii	ng Gear			_	General				_	_			_	1
	Bending				Bend	L	Grain		<u></u>	Oval			_	Pressure/Forced
	Centre f	Not Conce	ntric to	o/s	BOM/Route		Hardwa	re	ļ	Ove	r/Under	tolerance	<u> </u>	Temperature/Cure
·	Cracks				Broken/Damaged		Inspecti	on Incomplete	<u> </u>	Part	Incorre	ct	L	Weld
	Crushed	/Crimped		Ĺ	Burrs		Instruct	ions Incomplete/U	Jnclear	Part	Lost/M	issing		Wrong Stock Pulled
	Cuffs				Contamination		Mainte	nance	L	Part	Moved			
	Heat Tro	eat			Countersink		Mislabe	led	L	Posi	tioned V	Wrong	_	•
	Inspecti	on Strip ir	1 Tube		Cut Too Short		Misread	i		Pow	er Loss/	/Surge		Other
	Ripples	in Bend			Drill Holes		Offset							

Out of Calibration Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

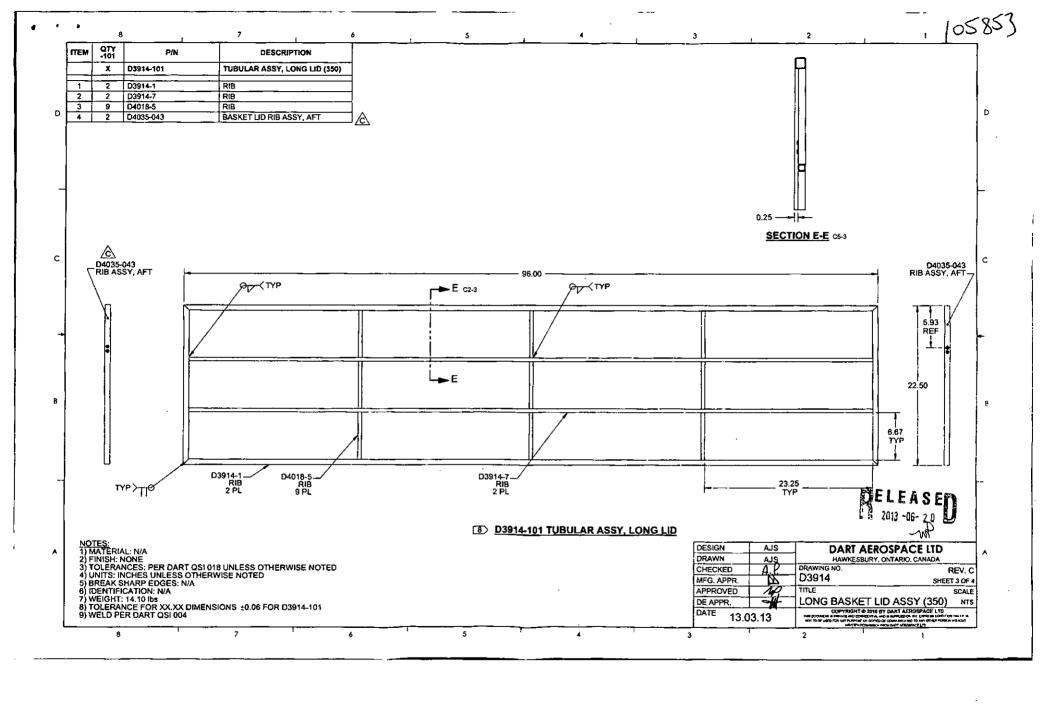
Rippies in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish Folio



											DQA:	Date:	
NCR:	Yes	/ No				WORK ORDER NON-	O	NFORM	MANCE / UPDATI		QA Closed:	Date:	
Mork Ord	ام					DISPOSITION			A	GAINST DE			
Work Order: Part No. NCR No.						Rework Scrap Use-as-is Work Order Update	-	Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite				Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update		Initial	Action		Sign &		
Cause		Date	Step	Qty	1	or Non-conformance	Ch	nief Eng	Description	n	Date	Verification	QC Inspector_
Doc/Data						<u> </u>							
Equip/Tooling	:[
Operator]											
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Setup]	İ		1		1						
Other	Г]								:			
Process	Г]											
Supplier													
Training											,		
Unapproved]	1										. <u>.</u>
						f	AUI	LT CATE	GORY				
Land	ing	Gear				General		_			•		•
1		Bending				Bend		Grain		<u> </u>	Ovalized		Pressure/Forced
		Centre N	ot Conce	ntric to	o/s [BOM/Route		Hardwa	ire		Over/Under	tolerance	Temperature/Cure
1		Cracks				Broken/Damaged		Inspect	ion Incomplete		Part Incorred	it	Weld
	Cracks Broken/Damaged Burrs							Instruct	ions Incomplete/Unclea	ar 🗀	Part Lost/Mi	ssing	Wrong Stock Pulled

Maintenance

Out of Calibration

Out of Sequence Outside Dimensions

Mislabeled

Misread

Offset

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Part Moved

Positioned Wrong

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

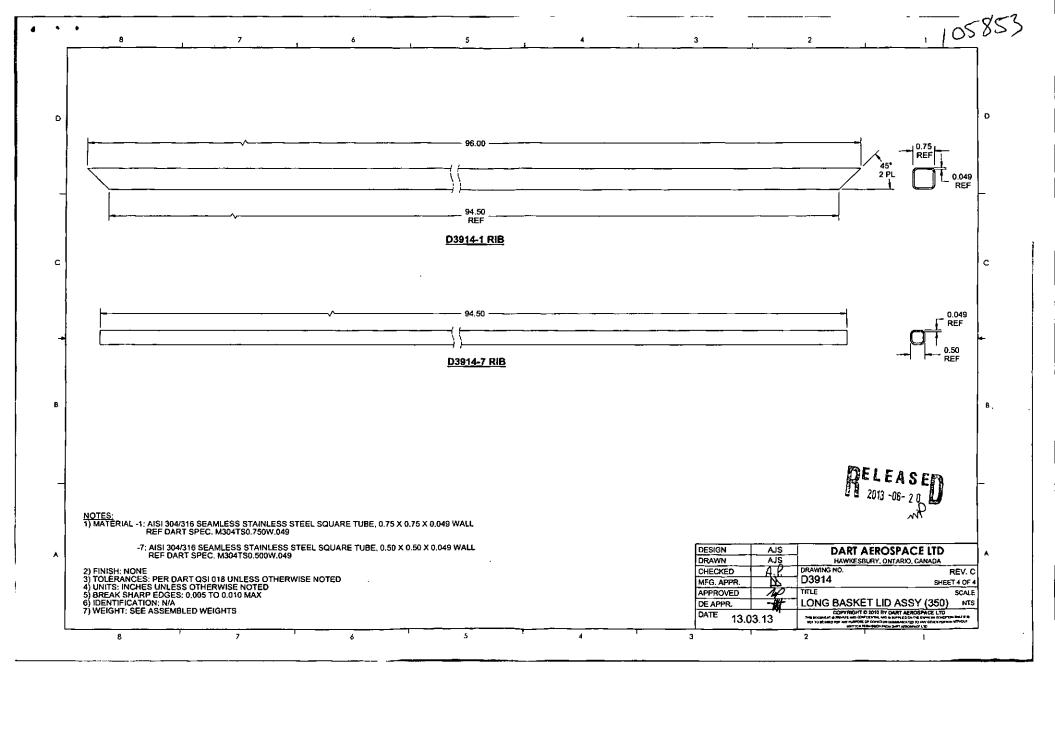
Crushed/Crimped

Inspection Strip in Tube

Torque Waves in Extrusion

Cuffs

Heat Treat



									DQA:	Date:					
NCR: Yes	s / No			WORK ORDER	WORK ORDER NON-CONFORMANCE / UPDATE										
Work Order:				DISPOSITIO	N	AGAINST DEPARTMENT/PROCESS									
Part No.				So	Rework Skid-tub Scrap Machinin			ning Small Fab		Water Jet d. Eng. Coor.	Engineering Quality				
NCR No.		·		Use-a Work Order Upo			noforming	re/Packaging Supplier	Other						
Root				Description of work order up	odate	Initial	Ac	tion	Sign &	-	·				
Cause	Date	Step	Qty	or Non-conformance	C	hief Eng	Desc	ription	Date	Verification	QC Inspector				
Doc/Data								i		-					
Equip/Tooling]									•					
Operator]										!				
Material	_]								i				
Setup	<u> </u>				İ										
Other	_									ļ					
Process	_]							;		ĺ					
Supplier	_							İ							
Training															

Pressure/Forced Bend Grain Ovalized Bending BOM/Route Over/Under tolerance Temperature/Cure Hardware Centre Not Concentric to O/S Broken/Damaged Inspection Incomplete Part Incorrect Weld Cracks Wrong Stock Pulled Crushed/Crimped Instructions Incomplete/Unclear Part Lost/Missing Burrs Contamination Part Moved Cuffs Maintenance Positioned Wrong Mislabeled Heat Treat Countersink Other Power Loss/Surge Inspection Strip in Tube Cut Too Short Misread Drill Holes Offset Ripples in Bend Out of Calibration Torque Waves in Extrusion Drawing Out of Sequence Turning Sequence Finish Folio Outside Dimensions Wave/Twist in Tube

FAULT CATEGORY

General

Unapproved

Landing Gear

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

1/05853 D4020-5: 95.25 D4020-7: 56.00 D 21.75 2.00 1.25 D4020-7 D4020-5 25.00 44.66 (LOCAL SECTION MESH SHOWN FOR CLARITY) DELEASE 1 2010 -03- 12 04020-7 MESH (350 BASKET SHORT, LID) (LOCAL SECTION MESH SHOWN FOR CLARITY) NOTES: 1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F REF DART SPEC. M304EX0.75-16F AJS DESIGN 2) FINISH: NONE DART AEROSPACE LTD 2) FINISH: NOINE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHAPP EDGES: N/A DRAWN JPH HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. A 5) BREAK SHARP EDGES! N/A
6) IDENTIFICATION: N/A
7) WEIGHT -5: 0.80 lbs APPROX
-7: 4.49 lbs APPROX
8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS
9) TOLERANCE ON XX.XX DIMENSIONS ± 0.06. D4020 MFG. APPR. SHEET 2 OF 4 APPROVED TITLE SCALE 350 BASKET MESH (BASE) DE APPR. NTS COPYRIGHT & 2010 SY DART AEROSPACE LTD

THIS DOCUMENT O PRIVATE AND COMPENTAL WID SERVINGS ON THE EMPIRES CONTYTO

ACT TO BE IMPERED AND PRIVATE OF CONTYTO COMPANION TO MAY CHAPT PRIVATE

ACT TO BE IMPERED AND PRIVATE OF CONTY ON THE PRIVATE PRIV DATE 10.03.04

DQA: Date: **WORK ORDER NON-CONFORMANCE / UPDATE** Yes / No NCR: QA Closed: Date: **AGAINST DEPARTMENT/PROCESS** DISPOSITION Work Order: Engineering Skid-tube Crosstube Water Jet Rework Quality Machining Prod. Eng. Coor. Small Fab Scrap Part No. Thermoforming Finishing Rec/Store/Packaging Other Use-as-is Supplier NCR No. Work Order Update Large Fab Composite Sign & Action Description of work order update Initial Root Description Date Verification QC Inspector Chief Eng Qtv or Non-conformance Date Step Cause Doc/Data Equip/Taoling Operator Material Setup Other Process Supplier Training Unapproved **FAULT CATEGORY Landing Gear** General Ovalized Pressure/Forced Bending Bend Grain BOM/Route Temperature/Cure Hardware Over/Under tolerance Centre Not Concentric to O/S

Inspection Incomplete

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Instructions Incomplete/Unclear

Broken/Damaged

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Burrs

Weld

Other

Wrong Stock Pulled

Part Incorrect

Part Moved

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Crushed/Crimped

Inspection Strip in Tube

Torque Waves in Extrusion

Cracks

Cuffs

Heat Treat